

Date: Thursday, 4/12/2007 8:20:41 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	31647				
Estimate Number	10530				
P.O. Number	N/A	Part Number	D2571		
This Issue	4/12/2007	S.O. No.	N/A		
Prsht Rev.	NC	Drawing Number	D2571 REV E		
First Issue	N/A	Project Number	N/A		
Previous Run	30592	Drawing Revision	E		
Written By		Material	N/A		
Checked & Approved By	<u>10</u> 07.04.12	Due Date	4/19/2007 Qty: 12 Um: Each		
Comment	Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: B 25353 (4.12)	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. B31647 Double check by: J.F.	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	M8Pmz 07/05/23 12
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	E6/6/2007 07/05/23 12
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	E6/6/2007 07/05/23 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng /, Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/05/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:20:41 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number: 31647		Part Number: D2571
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: SECOND CHECK		JL 07/05/27 12
7.0	POWDER COATING	POWDER COATING 
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		07-05-29 (12) Dark5/29
Job Completion		 W/0 5/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31647
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date	
A	0.438	0.443	DT8682	.4510	.4500	0.440	0.440			
B	1.745	1.755		1.749	1.748	1.747	1.748			
C	3.495	3.505		3.499	3.498	3.500	3.499			
D	1.745	1.755		1.749	1.748	1.747	1.748			
E	7.990	8.010		8.003	8.003	8.004	8.000			
F	0.490	0.510		0.500	0.494	0.496	0.499			
G	0.257	0.262	DT8683	.260	.260	0.260	0.260			
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377			
I	0.490	0.510		0.504	0.497	0.500	0.502			
J	1.174	1.184		1.175	1.175	1.175	1.178			
K	0.558	0.578		0.563	0.563	0.564	0.564			
L	1.174	1.184		1.175	1.175	1.175	1.178			
M	1.490	1.500		1.492	1.492	1.492	1.494			
N	2.495	2.505		2.496	2.498	2.497	2.496			
O	3.869	3.879		3.873	3.873	3.872	3.872			
P	0.115	0.135		0.126	0.126	0.126	0.126			
Q	0.115	0.135		0.135	0.135	0.135	0.135			
R	0.240	0.260		0.250	0.250	0.250	0.250			
S	0.115	0.135		0.128	0.126	0.127	0.126			
T	0.178	0.198		0.188	0.188	0.188	0.188			
U	2.940	2.980		2.966	2.960	2.960	2.960			
V	0.230	0.250		0.240	0.244	0.238	0.240			
W	0.115	0.135		0.120	0.120	0.120	0.123			
X	0.308	0.313		0.311	0.311	0.311	0.310			
Y	0.760	0.765		0.765	0.765	0.765	0.765			
Z	0.352	0.372		0.365	0.365	0.365	0.365			
AA	0.470	0.530		0.500	0.500	0.500	0.500			
AB	0.615	0.635		0.628	0.630	0.628	0.628			
AC	0.053	0.073		.063	.063	.063	.063			
AD	0.240	0.260		0.249	0.247	0.250	0.247			
AE	1.375	1.395		1.387	1.387	1.387	1.386			
AF	0.115	0.135		0.135	0.135	0.135	0.135			
AG	0.240	0.280		0.260	0.260	0.260	0.260			
AH	0.240	0.260		0.248	0.248	0.247	0.248			
AI	2.000	2.020		2.001	2.001	2.001	2.001			
AJ	0.023	0.043		.032	.032	.032	.032			
Accept/Reject										

Measured by:	M8/E	Audited by:	SA
Date:	07/05/24	Date:	07.05.25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31647
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.745	1.745	1.745	1.745		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.745	1.745	1.745	1.745		
E	7.990	8.010		8.005	8.003	8.002	8.000		
F	0.490	0.510		0.497	0.497	0.497	0.502		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.504	0.500	0.502		
J	1.174	1.184		1.176	1.178	1.178	1.177		
K	0.558	0.578		0.564	0.564	0.566	0.566		
L	1.174	1.184		1.176	1.178	1.178	1.177		
M	1.490	1.500		1.495	1.493	1.492	1.492		
N	2.495	2.505		2.498	2.497	2.496	2.499		
O	3.869	3.879		3.870	3.874	3.870	3.870		
P	0.115	0.135		0.126	0.126	0.126	0.124		
Q	0.115	0.135		0.131	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.250	0.248		
S	0.115	0.135		0.127	0.126	0.126	0.128		
T	0.178	0.198		0.184	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.246	0.244		
W	0.115	0.135		0.120	0.116	0.118	0.122		
X	0.308	0.313		0.311	0.311	0.311	0.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.365	0.365	0.365		
AA	0.470	0.530		0.506	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.627	0.630	0.635		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.247	0.249	0.251		
AE	1.375	1.395		1.388	1.386	1.386	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.249	0.250	0.252		
AI	2.000	2.020		2.002	2.001	2.001	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EP / am
Date:	05/05/20

Audited by:	JI
Date:	07/05/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	KA SW

DART AEROSPACE LTD	Work Order:	31647
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

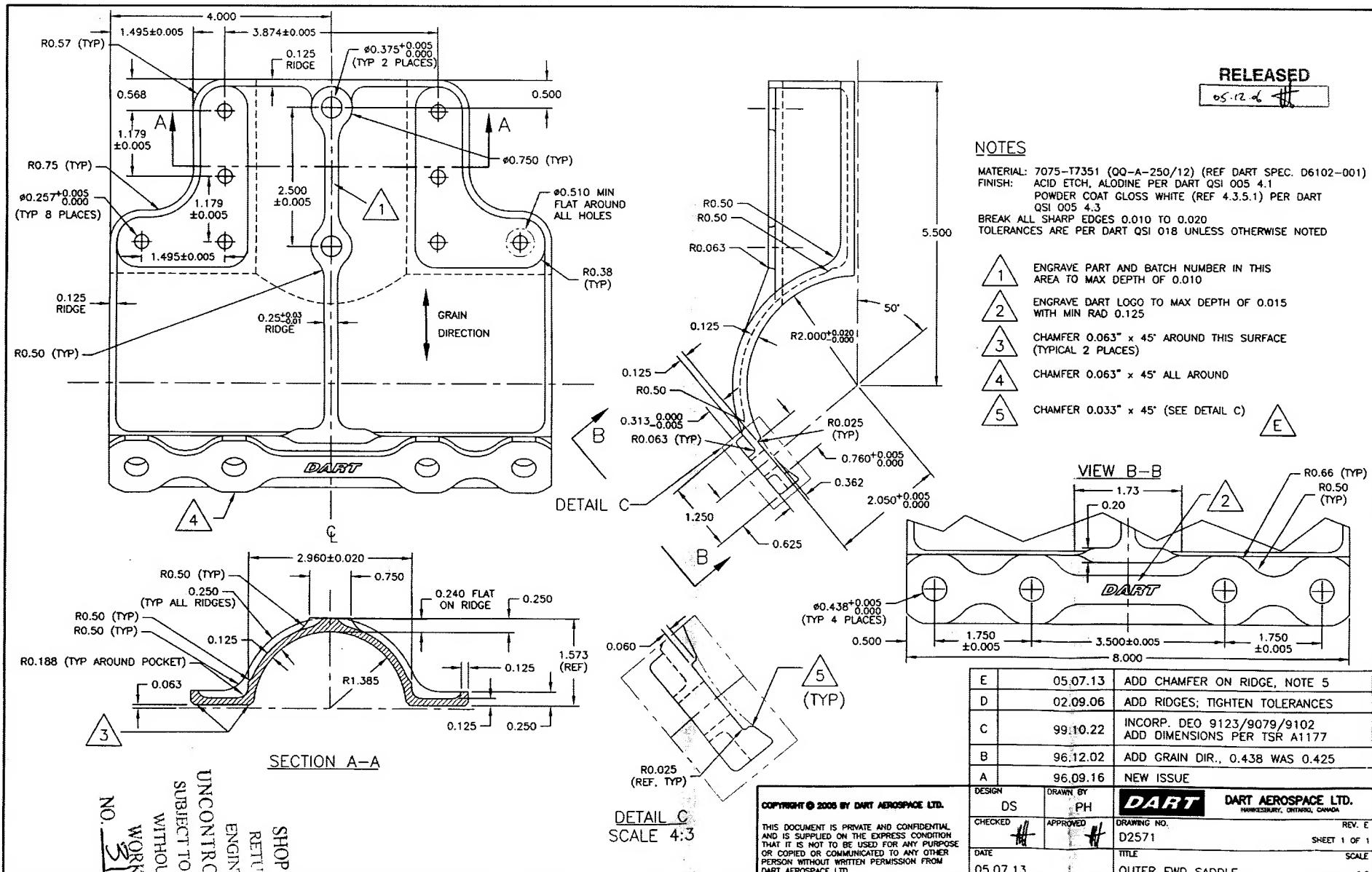
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B	1.745	1.755		1.750	1.749	1.749	1.749		
C	3.495	3.505		3.506	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.749	1.749	1.750		
E	7.990	8.010		8.000	7.999	8.003	8.003		
F	0.490	0.510		0.505	0.506	0.506	0.502		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	-DT8684	0.374	0.376	0.376	0.376		
I	0.490	0.510		0.501	0.502	0.503	0.504		
J	1.174	1.184		1.178	1.178	1.177	1.177		
K	0.558	0.578		0.567	0.566	0.568	0.573		
L	1.174	1.184		1.178	1.178	1.177	1.177		
M	1.490	1.500		1.494	1.493	1.494	1.495		
N	2.495	2.505		2.499	2.499	2.500	2.500		
O	3.869	3.879		3.872	3.871	3.871	3.871		
P	0.115	0.135		0.126	0.125	0.125	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.248	0.249	0.250		
S	0.115	0.135		0.131	0.130	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.243	0.246	0.242	0.241		
W	0.115	0.135		0.121	0.122	0.122	0.119		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.761	0.761	0.761		
Z	0.352	0.372		0.365	0.365	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.635	0.635	0.635	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.252	0.253	0.253	0.249		
AE	1.375	1.395		1.389	1.383	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.255	0.255		
AH	0.240	0.260		0.250	0.253	0.250	0.250		
AI	2.000	2.020		2.003	2.000	2.002	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: *gml*
Date: 07/05/26

Audited by: *JL*
Date: 04/05/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JL</i>	<i>JL</i>



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